

Work Order ID 66522

Friday, February 18, 2011 12:02:52 PM



Page 1

Item ID: D206-642-141

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 2/18/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2650

Rev F

200

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

PULL FROM STOCK:
1 X D206-642-141 B18613
1 X D206-642-141 B9575
1 X D206-642-112 B25504

SCRAP/DESTROY - OLD REV

11/03/01

320

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

11/03/01

11.03.01

Picklist Print

Friday, February 18, 2011 12:02:50 PM

Page 1

Work Order ID: 66522



Parent Item: D206-642-141



Parent Item Name: Replacement Skidtube

Start Date: 2/18/2011

Required Date: 2/22/2011

Start Qty: 2.00

Required Qty: 2.00

Comments:
 IPP Rev:H05.10.11ECN 847 & 901; Add Tow Ring and GHW Kit;
 CHG004KJ/CP/JLM IPP rev J 10.02.19 per PAR 09-043 EC verified
 by:DD
 IPP Rev:I 08-06-10 chg D2654-3 to -1 (seq 13) DD verified by:ec
 IPP Rev:J 08-07-14 remove QC5 at seq.41 DD verified by:EC
 IPP rev:K 08-09-29 revF as per dwg DD verified by:
 IPP Rev: L 08.11.27 QC10 replaces QC9 at step 24 KJ Verified by:
 EC IPP Rev:M 09-02-26 as
 per DSI9440 rev.a DD verified by: EC
 IPP Rev:N 09-04-14 @ chg006 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-642-112 Skidtube RH		Manufactured	No				Each	1.0000		1		11/02/01	
				<u>Location</u>				<u>Loc Qty</u>					
				FG080				1					
				44224				1				11/03/01	
D206-642-141 Replacement Skidtube		Manufactured	No				Each	0.0000		2			

List Lots

Friday, February 18, 2011 8:04:26 AM

Page 1 of 1

Criteria : Item ID: d206-642-141 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt Lot Code	Type Code	Comments
D206-642-141 Replacement Skidtube	Main Warehouse FG080	18613 +	2/16/2011	1.0000	QC21	CHG001	
	Main Warehouse FG080	9575 +	2/16/2011	1.0000	QC21	CHG001	
Total:				2.0000			

Send
revised
list to
Angie

66522

h

REFERENCE ONLY

List Lots

Friday, February 18, 2011 8:04:37 AM

Page 1 of 1

Criteria : Item ID: d206-642-112 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Lot Code	Type Code	Comments
D206-642-112 Skidtube RH	Main Warehouse FG080	25504	2/16/2011	1.0000		QC21		
	Main Warehouse FG080	44224	2/16/2011	1.0000		QC21	CHG004	
Total:				2.0000				

W

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG CW D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
08-07-23